

Work Order ID 97448

Tuesday, February 19, 2013 3:21:54 PM

97448

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Item ID: D3121-21

Accept

N900040100

Setup Start

NS1

Revision ID:

Item Name: Bolt

Stop

NS2

Start Date: 2/19/2013 Start Qty: 40.00

40

Cust Item ID:

Required Date: 2/22/2013 Req'd Qty: 40.00

40

Customer:

Reference:

Approvals: Process Plan: MWF

Date: 2-19

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
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D3121	Rev E
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100	0.00
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100

Hardinge

Hardinge CNC LATHE SMALL

Memo

0.00

2/13-02-20

20

0

Hardinge CNC Lathe Small

1-Turn D3121-21 2-Identify as D3121-213-Deburr break all sharp edges
0.005" to 0.010"

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Quality Control

2/13-02-20

20

0

120

QC8- Inspect parts - second check

0.00

120

QC

Quality Control

2/13-02-20

20

0

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Page 2

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Start

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NS2

Start Date: 2/19/2013 Start Qty: 40.00

40

Cust Item ID:

Required Date: 2/22/2013 Req'd Qty: 40.00

40

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run

Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2Sequence ID/
Work Center ID

130

130

Packaging

Packaging

Operation
DescriptionIdentify as per dwg & Stock Location: ST235Set Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

0.00

20x

Sp

13-220

140

140

QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

13/2/21 HJ

ABD 2/20

Picklist Print

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Page 1

Work Order ID: 97448

Parent Item: D3121-21

Parent Item Name: Bolt

Start Date: 2/19/2013

Required Date: 2/22/2013

Start Qty: 40.00

Required Qty: 40.00

Comments: IPP A04.02.09New issueKJ/DS
IPP Rev:B ECN 1060 07-11-12 DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M303H0.500, 303 HEX BAR .500		Purchased	No			110	f	8.4660	0.0417	.917	1.668		13-02-20

Location	Loc Qty	Loc Code
MAT018	8.466	
109778	6.262	
121380	1.4	
123279	0.804	.917

DART AEROSPACE LTD	Work Order:	9-7448
Description: Bolt	Part Number:	D3121-21
Inspection Dwg: D3121	Rev: E	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

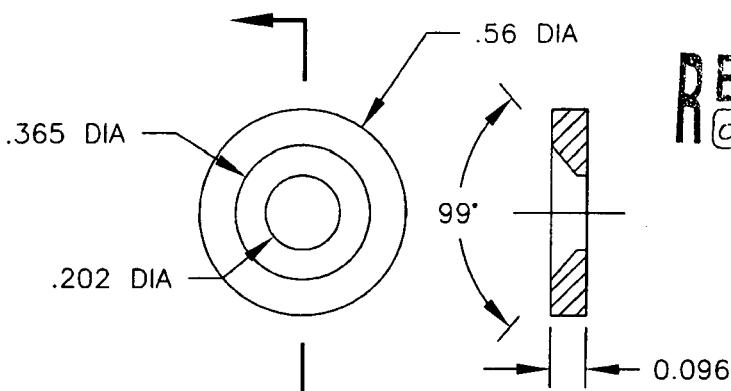
X First Article Prototype

Measured by:		Audited by:		Prototype Approval:	N/A
Date:	13-02-20	Date:	3.2.20	Date:	N/A

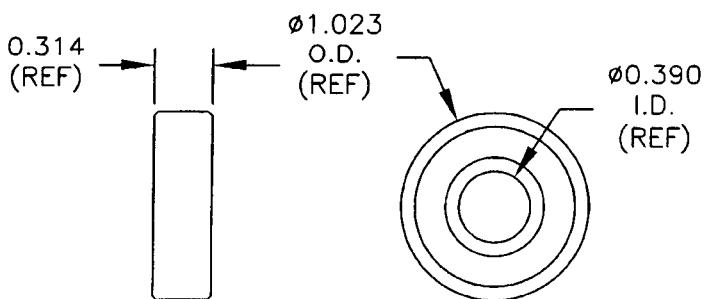
Rev	Date	Change	Revised by	Approved
A	04.02.27	New Issue	KJ/RF	
B	06.03.09	Dwg Rev. updated	KJ/JLM	
C	06.06.14	Dwg Rev. updated	KJ/JLM	
D	08.01.16	Dwg Rev. updated	KJ/EC/DD,	
E	08.07.23	Dimensions updated	KJ/DD	 

DART

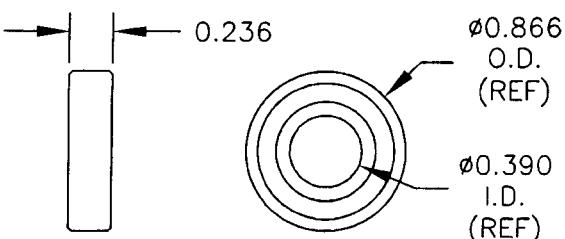
DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3121	REV. E SHEET 10 OF 10
DATE 07.11.07	TITLE BRACKET ASSEMBLY	SCALE 1:1	

**D3121-17 WASHER (SCALE 2:1)**

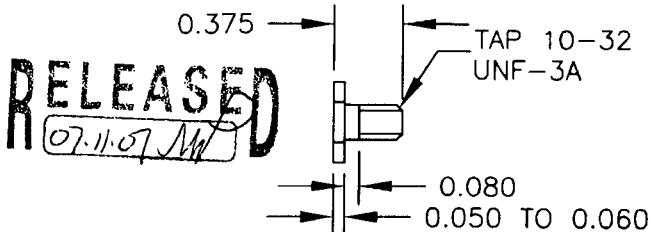
- 1) REPLACES PREMIER P/N B32-23001-17
- 2) MATERIAL: AISI 303 SS ROUND BAR, ANNEALED (REF DART SPEC. M303R)
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.015

**D3121-19 BEARING (SCALE 1:1)**

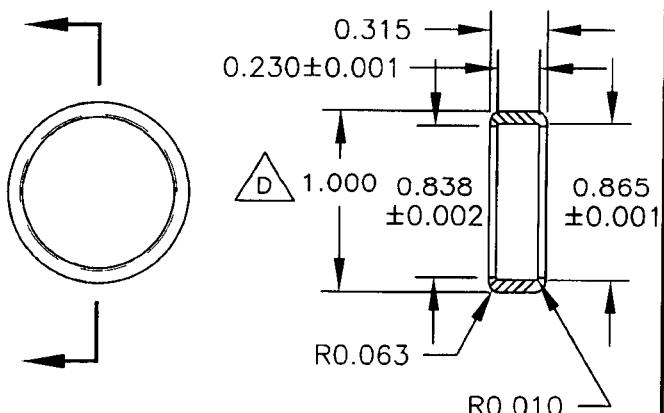
- 1) POSSIBLE SUPPLIER: KING BEARING P/N 6000-2ZJ/EM
FAFNIR P/N 9100KDD
- 2) ALL DIMENSIONS ARE IN INCHES

**D3121-23 BEARING (SCALE 1:1)**

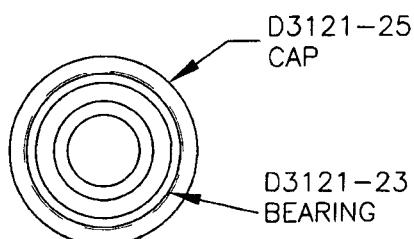
- 1) POSSIBLE SUPPLIER: SKF P/N 61900-2Z
OR KML P/N 6900-2Z
- 2) ALL DIMENSIONS ARE IN INCHES

**D3121-21 BOLT (SCALE 1:1)**

- 1) MATERIAL: AISI 303 SS HEX, ANNEALED (REF DART SPEC. M303H0.500)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.015

**D3121-25 CAP (SCALE 1:1)**

- 1) MATERIAL: DELRIN ROD, Ø1.25 (REF DART SPEC. M-DELRIN-R1.250)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES

**D3121-241 BEARING ASSEMBLY (SCALE 1:1)**